Work Orde July 14, 2009 1.		320											Page
Item ID: Revision ID: Item Name:	D2174-041 E Web, 205	A		A	Accept						Setup Sta		
	7/15/09	Start Qty: 10.00 Req'd Qty: 10.00	10				st Item l stomer:	D:				114411141	HEND (IIB (IB) 1633)
Approvals:	Process Pla	n:	Date:		Tooling: SPC (Y/N):			ate:			Run Sta Sto		
Sequence ID/ Work Center II)	Operation Description			Set Up/ Run Hours		raw umber	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr											
D2174	Rev	E											
100 		Small Fab	<u></u>		0.00	, ,	A 11 See Alder			E	509/0	67/2	7. (
Small Fab		Memo 1 - Assembl	e as per Dwg	g D2174-041□2-	0.00 Identify as D2174-04	1							

110

QC5- Inspect part completeness to step on W/O

Memo

0.00

501/467

Quality Control

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

120 Powdercoat

Powder Coating

FIOVEN TEMPERATURE: BK 0907-27 (6).

W/O:			WO	RK ORDER CHAN	GES				
DATE	STEP	PR	OCEDURE CHA	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Categ	ory:	NCR: Yes	No DQ	A:	Date: _	
					QA:	N/C Close	d:	_ Date: _	
NCR:			WORK ORDE	R NON-CONFORM	MANCE (NC	R)			
DATE	STEP	Description of NC	L		ection B	Verific	cation	Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat	Section Sectio	on C	Chief Eng	QC Inspector
•									

Work Order ID 50320

July 14, 2009 12:01:52 PM

Page 2

Item ID:

D2174-041

Accept

Setup Start

Stop



Revision ID: Item Name:

Ε

Required Date: 7/15/09

Web, 205

7/15/09

Start Qty: 10.00

Req'd Qty: 10.00

Cust Item ID: Customer:

Draw

Number

Reference:

Start Date:

Approvals:

Process Plan:

QC: Date:

Tooling: Date: _____

SPC (Y/N):

Date:

Date:

Draw

Rev.

Plan

Code

Run Start

Reject

Qty

Accept

Qty

Stop



Insp.

Reject

Sequence ID/ **Work Center ID**

130

QC

Quality Control

Operation Description

QC3- Inspect Part Finish

Memo

Set Up/ **Run Hours**

0.00

0.00

0.00

0.00

09-07-28

Number Stamp

140

Small Fab Small Fab

Small Fab

Memo

Memo

Install nuts & bolts loosely as per Dwg D2274

150

QC

Quality Control

QC5- Inspect part completeness to step on W/O

=> Sorlulos

W/O:	<u> </u>		WC	RK ORDER CHAN	GFS			
DATE	STEP	PR	OCEDURE CHAI		Ву	Date C	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cateo	ory:				
			WORK ORDE	ED NON CONFORM			Date: _	
NCR:				ER NON-CONFORM	MANCE (NCP	()		
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Se Action Description Chief Eng	Sign 8	Verificati Section (Approval Chief Eng	Approval QC Inspector
							, , , , , , , , , , , , , , , , , , , ,	

Work Order ID 50320

July 14, 2009 12:01:52 PM

Required Date: 7/15/09



Page 3

Item ID:

D2174-041

Accept

Setup Start



Revision ID: Item Name:

Web, 205

Ε

7/15/09

Start Oty: 10.00

Req'd Qty: 10.00

Cust Item ID: Customer:

Reference:

Start Date:

Approvals:

Process Plan:

Date: Date: Tooling:

SPC (Y/N):

Set Up/

Run Hours

Date:

Run Start

Reject

Qty

Stop

Stop

Sequence ID/

Work Center ID

160

Packaging Packaging

Operation Description

Identify as per dwg & Stock Location:

Memo

Memo

0.00

Draw Number Draw Rev.

Date:

Plan Code

Accept **Qty**

Reject Number

Insp. Stamp

170

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

0.00

09/07/29

W/O:			WO	RK ORDER CHANG	ES	****			
DATE	STEP	PR	OCEDURE CHAP	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Categ	jory:	_ NCR: Yes	No DQ	A:	Date:	
								_ Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR)			
DATE	STEP	Description of NC		Corrective Action Section		Verific	cation	Approval	Approval
	OIL!	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti	on C	Chief Eng	QC Inspector
							ı		

NOTE: Date & initial all entries

July 14, 2009 12:01:51 PM

Work Order ID: 50320

Parent Item:

D2174-041RevE

Parent Item Name: Web, 205

Comments.



Start Date: 7/15/09

Required Date: 7/15/09

Start Oty: 10.00

Required Oty: 10.00

Comments:								3	tart Qty: 10.00	U	Required Qty:	10.00
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch		Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN526C832R14		Purchased	No	· <u>·</u> ··· · · ·		140	Each	1,033.000	40.0000	260,	9/07/27	7
				<u>Warehou</u>	<u>ise</u>	Loc (<u>Oty</u>	Loc Code		,	,	
				Loca	<u>ition</u>							
				Main Wa	rehouse							
				ST			1033					
					104916		1033		_			
AN960JD8		Purchased	No			140	Each	953.0000	40.0000	4	09/07/	27_
				Warehou	<u>ıse</u>	Loc (<u>Qty</u>	Loc Code			•	
				Loca	tion						,	
				Main Wa	rehouse							
				ST			953					
					107091		9		_			
					108335		11					
					110382 110917		48		_			
					111578		882			V		
							_					

Manufactured

No

Web

D2174-1RevE

Each

0.0000

100

10.0000 ES 09/07/27

	TOSPACE EN	Y					
W/O:		WORK ORDER C					
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #: Fault Category:	NCR: Yes	No DQ	A:	_ Date: _	
			QA:	N/C Close	d:	_ Date: _	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC		Corrective Action Section B		Verification	Approval	A1	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector	

July 14, 2009 12:01:51 PM

Work Order ID: 50320

Parent Item:

· D2174-041RevE

Parent Item Name:

Web, 205



Start Date: 7/15/09

Required Date: 7/15/09

Comments:								5	Start Qty: 10.00)	Required Qty: 1	10.00
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2175-1RevE		Manufactured	No			100	Each	2.0000	10.0000	Spo	9/07/27	Z
ŭ				Warehoo Loca		Loc	<u>Qtv</u>	Loc Code	\mathcal{B}	5036	(6)	
				Main Wa	rehouse							
				ST	31691		2 2					
D2175-2RevE		Manufactured	No		31091	100	Each	1.0000	10.0000	Es	09/07/0	/ 27
Angle RH				<u>Wareho</u> <u>Loca</u>		Loc	<u>Qty</u>	Loc Code	350	230		
				Main Wa			1					
MS20470AD4-6	1311 1111 1111 1111 1111 1111 1111 11	Purchased	No		48413	140	Each	1,785.000	190.0000	G	509/07	67
Rivet, Universal Head				Wareho Loca		Loc	<u>Qty</u>	Loc Code				
				Main Wa	arehouse		1505					
				ST	109371		1785 64		_			
					110915		1721		_	1		

W/O:			WC	RK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
13 - 17 <u>-</u>									
Part No	:	PAR #:	Fault Cateç	Jory:	NCR: Yes	No DQA:		Date:	
					QA: N	/C Closed:		_ Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR)			
DATE	STEP	Description of NC	Initial	Corrective Action Section Action Description	on B Sign &	Verificat		Approval	Approval
		Section A	Chief Eng	Chief Eng	Date	Section	С	Chief Eng	QC Inspector

July 14, 2009 12:01:51 PM

Work Order ID: 50320

Parent Item:

D2174-041RevE

Parent Item Name:

Web, 205



ST

Last

Start Date: 7/15/09

Required Date: 7/15/09

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name

Replacement Mfg/ Item ID

Purch

Purchased

Bin Primary Location Item

No

Location

Route Seq ID

100

Unit of Measure Hand

Each

Qty on

138.0000 40.0000

Remaining Qty To Pick

Qty Issued Date Issued

Status

MS21042L08

Comments:

Nut

Loc Code Loc Qty Warehouse Location Main Warehouse

> 138 110002 24 111889 114

M/12243



Dart Ae	rospace	Ltd							
W/O:			W	ORK ORDER CHANGES					
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
··-									
Part No	:	PAR #:	Fault Cate	gory: NO	R: Yes	No DQ	A :	_ Date:	
					QA: N	/C Close	d:	_ Date: _	
NCR:			WORK ORD	ER NON-CONFORMANC	E (NCR)			4
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section B Action Description Chief Eng	Sign &	Verific Secti	cation on C	Approval Chief Eng	Approval QC Inspector
		·	Official Eng	Chief Eng	Date		1		
		·							
	1						į		

Dart Ae	rospace	Ltd							
W/O:			WC	RK ORDER CHANG	ES				·+ · · · · · · · · · · · · · · · · · ·
DATE	STEP	PRO	CEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cated	iorv:	NCR: Yes	No DQ) A :	Date:	
								Date: _	
NCR:		V	ORK ORDI	R NON-CONFORMA	NCE (NCF	()		*.*	
DATE	OTED	Description of NC		Corrective Action Section	on B	Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	1	tion C	Chief Eng	QC Inspector
							;		



06.09.25	DATE
WEB	TIMLE

	85'
R0.35 (TYP) —	3.012 - 1.629 - (1.506 PITCH)
4.283	(1.508 PITCH) #0.172 (4 HOLES)
2.692	GRAIN DIRECTION 6.400
0.900	0.821 (TYP)
1 075	#0.128 (22 HOLES) 0.300 1.375
1.075 —— 0.550 ——	11.550 (1.050 PITCH)
	5

D2174-1

NOTES:

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ANY PURPOSE OR COPIED

1) MATERIAL: 2024-T3 SHEET (QQ-A-200/4) 0.063 THICK (REF. DART SPEC. M2024T3S.063)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) BREAK ALL SHARP EDGES 0.005 TO 0.010 5) ALL DIMENSION ARE IN INCHES



B 1:3	WEB	
SCALE	31ML	
174 SHEET 2 OF 2	D2174	
ING NO. REV. E	DRAWING NO.	
HAWKESBURY, ONTARIO, CANADA		
DART AFROSPACE ITD		

W/O:		WORK ORDER CHANGES									
DATE STEP		PROCEDURE CHANGE			Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
							Prod Mgr				
							į.				
.											
Part No:		PAR #:	Fault Cate	gory:	_ NCR: Yes N	lo DQA:	Date:				
					QA: N/C	C Closed:	Date: _				
NCR:		,	WORK ORDE	ER NON-CONFORMA	ANCE (NCR)						
DATE	STEP	Description of NC Section A		Corrective Action Section		Verification		Approval			
DATE			Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	QC Inspector			
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		4.4									
				100							
	1		1 1			1	ı	1			